

CLAIMS

1. A process for the manufacturing of a decorative surface element, which element comprises a base layer and a decorative upper surface, characterised in that,
- a wetting repellent lacquer is printed in a predetermined pattern on the decorative upper surface, the wetting repellent lacquer covering only parts of the decorative upper surface whereupon,
 - a wear layer of a UV or electron beam curing lacquer is applied on top of the decorative upper surface which UV or electron beam curing lacquer is repelled from the parts of the surface being covered by the wetting repellent lacquer whereby a surface structure is achieved.
2. A process according to claim 1, ~~characterised~~ ^{CHARACTERIZED} in that the UV or electron beam curing lacquer consists of an acrylic, epoxy or a maleimide lacquer.
3. A process according to claim 1 ~~or 2~~, ~~characterised~~ ^{CHARACTERIZED} in that the wear layer is applied in several steps with intermediate partial curing.
4. A process according to ~~any of the claims 1-3~~, ~~characterised~~ ^{CLAIM 1, CHARACTERIZED} in that the wear layer includes hard particles with an average particle size in the range 50nm - 150µm.
5. A process according to claim 4, ~~characterised~~ ^{CHARACTERIZED} in that the hard particles consists of for example silicon oxide, α-aluminium oxide or silicon carbide.
6. A process according to claim 4, ~~characterised~~ ^{CHARACTERIZED} in that the main part of the hard particles consists of for example silicon oxide, α-aluminium oxide or silicon carbide while a smaller amount of the hard particles consist of diamond.
7. A process according to claim 6, ~~characterised~~ ^{CHARACTERIZED} in that the hard particles consisting of diamond is in the average particle size range 50nm - 2µm and is placed close to the upper surface of the wear layer.

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- A 8. A process according to claim 1, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer is constituted of a UV or electron beam curing lacquer with a content of silicone polymer.
- A 9. A process according to claim 8, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer comprises UV or electron beam curing acrylic, epoxy or a maleimide lacquer.
- A 10. A process according to claim 8 or 9, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer is translucent.
- A 11. A process according to claim 8 or 9, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer is semi-translucent.
- A 12. A process according to claim 11, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer includes pigmentation which creates a structure enhancing shadow effect in the structure.
- A 13. A process according to claim 11, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer includes a matting agent which creates a structure enhancing effect in the structure.
- A 14. A process according to claim 8 or 9, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer is cured before the step where the wear layer is applied.
- A 15. A process according to claim 1, ~~characterised~~ ^{CHARACTERIZED} in that the decorative upper surface comprises a decor layer, which decor layer originates from a digitally stored original, that the digitally stored original is processed in order to achieve a digital structure original whereby a surface structure that in every essential aspect matches the decor is achieved.
- A 16. A process according to claim 8 or 11, ~~characterised~~ ^{CHARACTERIZED} in that the wetting repellent lacquer is applied by means of an ink-jet printer.
- A 17. A process according to claim 1, ~~characterised~~ ^{CHARACTERIZED} in that the base layer consists of a particle board or a fibre board.

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項目	単位	1990年	1991年	1992年	1993年	1994年	1995年	1996年	1997年	1998年	1999年	2000年	2001年	2002年	2003年	2004年	2005年	2006年	2007年	2008年	2009年	2010年	2011年	2012年	2013年	2014年	2015年	2016年	2017年	2018年	2019年	2020年	2021年	2022年	2023年	2024年	2025年	2026年	2027年	2028年	2029年	2030年	2031年	2032年	2033年	2034年	2035年	2036年	2037年	2038年	2039年	2040年	2041年	2042年	2043年	2044年	2045年	2046年	2047年	2048年	2049年	2050年	2051年	2052年	2053年	2054年	2055年	2056年	2057年	2058年	2059年	2060年	2061年	2062年	2063年	2064年	2065年	2066年	2067年	2068年	2069年	2070年	2071年	2072年	2073年	2074年	2075年	2076年	2077年	2078年	2079年	2080年	2081年	2082年	2083年	2084年	2085年	2086年	2087年	2088年	2089年	2090年	2091年	2092年	2093年	2094年	2095年	2096年	2097年	2098年	2099年	2100年																																																																		
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